

Work Order ID 55030

January 5, 2010 1:21:10 PM



Page 1

Item ID: D2666-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft In 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

PM

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2666

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. 1-Inspect part number and batch number are programmed correctly. 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6

MMJ=
10/01/22

6 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

MMJ=
10/01/22

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MMJ=
10/01/22

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2666-2

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Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft In 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



Y.A 10/01/22

6

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> HU 10/01/25



(X6)

0

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1113170

=> HU 10/01/26



(X6)

0

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:00AM

OVEN TEMPERATURE:

7:30AM FINISH TIME:

320°C

W/O:		WORK ORDER CHANGES					
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Work Order ID 55030

January 5, 2010 1:21:10 PM

Page 3

Item ID: D2666-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, RH Fwd Aft In 206

Start Date: 05/01/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

BK 10-00-26

⑥ ②

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 426

0.00

10-1-27

⑥ ②

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

10/01/27

QC

Memo

0.00

Quality Control

WK 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

January 5, 2010 1:21:15 PM

Page 1

Work Order ID: 55030

Parent Item: D2666-2

Parent Item Name: Saddle, RH Fwd Aft In 206

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg Part	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	26.0000	6.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

26

46409

26

MMF

6

10/01/22

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	55030
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	6
A	0.100	0.140		.108	.108	.106	.107	.108	.107
B	0.100	0.140		.109	.109	.105	.109	.109	.109
C	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
D	0.100	0.180		.133	.135	.134	.135	.135	.138
E	0.210	0.230		.230	.231	.231	.230	.230	.231
F	1.313	1.343		1.326	1.326	1.326	1.325	1.326	1.326
G	0.240	0.280		.250	.247	.247	.247	.247	.247
H	0.615	0.685		.641	.645	.638	.654	.654	.645
I	1.125	1.145		1.135	1.137	1.137	1.137	1.137	1.137
J	0.990	1.010		.997	.999	.999	.999	.999	.999
K	0.235	0.240		.235	.235	.236	.236	.236	.236
L	0.510	0.515		.510	.510	.510	.510	.510	.510
M	0.100	0.120		.111	.110	.118	.111	.110	.111
N	1.565	1.585		1.575	1.577	1.576	1.576	1.576	1.575
O	5.990	6.010		6.001	6.003	6.004	6.001	6.002	6.002
P	1.245	1.255		1.248	1.247	1.247	1.247	1.247	1.247
Q	2.495	2.505		2.500	2.498	2.498	2.499	2.498	2.498
R	0.490	0.510		.498	.497	.498	.499	.498	.499
S	0.313	0.318		.316	.316	.315	.316	.316	.316
T	2.495	2.505		2.501	2.499	2.500	2.500	2.500	2.500
U	1.357	1.367		1.361	1.362	1.362	1.362	1.362	1.363
V	0.315	0.322		.317	.317	.317	.317	.317	.317
W	0.540	0.560		.549	.550	.550	.550	.550	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	1.680
Y	0.257	0.262		.260	.260	.260	.260	.260	.260
Z	0.178	0.198		.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	MME
Date:	10/01/22

Audited by:	LA
Date:	10/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

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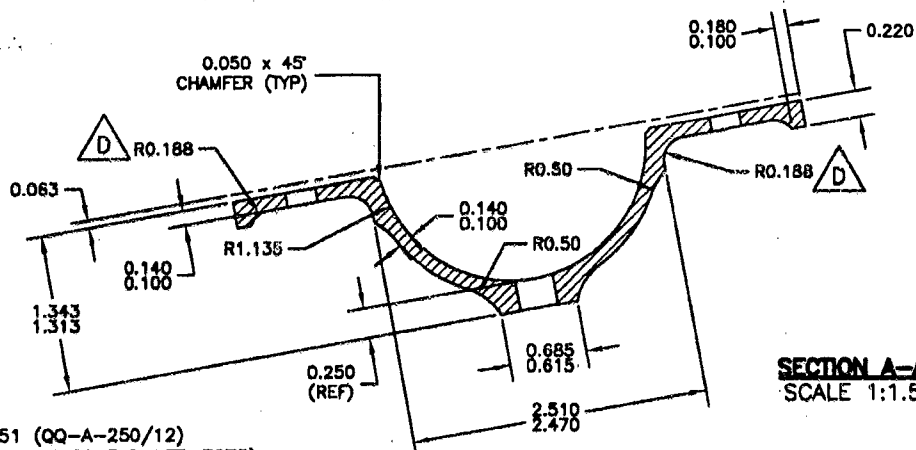
DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

RELEASED

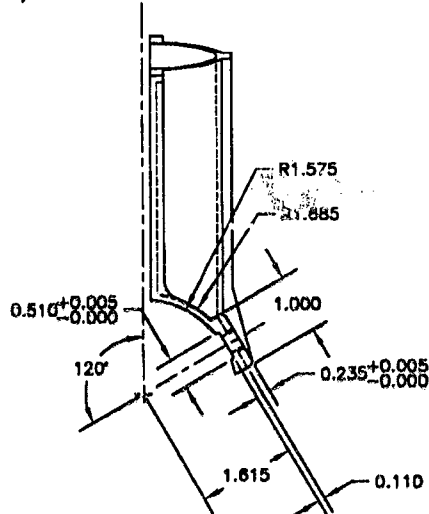
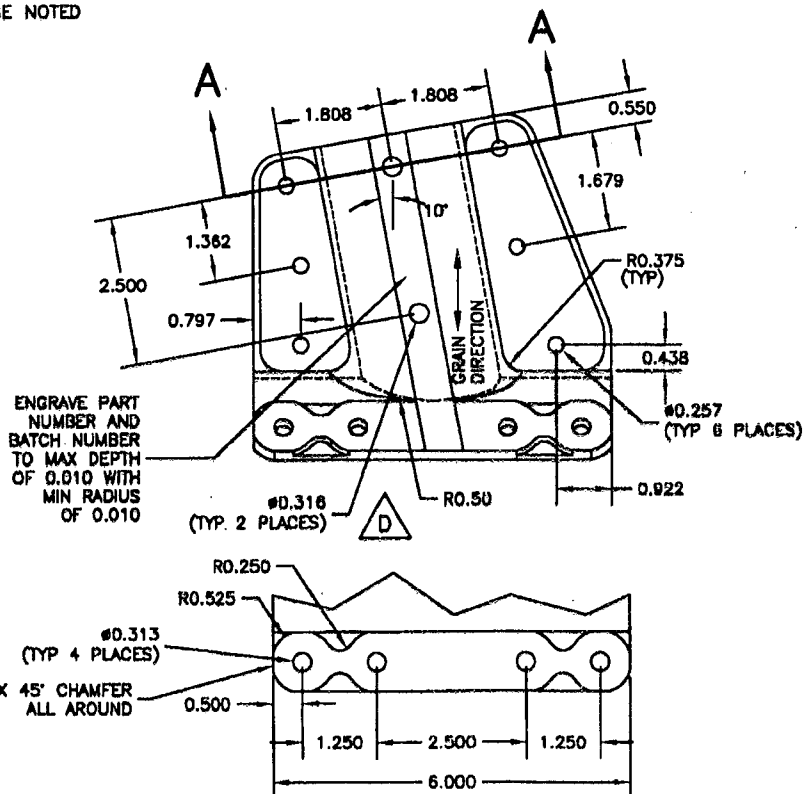
07 02 12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55030
10-1-05



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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